


Work Order ID 71909

Wednesday, July 13, 2011 12:32:47 PM

Item ID: D4406-041
Revision ID: PRELIM
Item Name: Fwd Wearplate Assembly

Start Date: 7/13/2011 Start Qty: 1.00
Required Date: 7/15/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: 
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4406

PA4

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per dwg D4406
prog rev: PA4
dwg rev: PA4

2-Deburr if required

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00



PRELIMINARY ISSUE

Page 1

Accept



Setup Start



Stop



Cust Item ID:

Customer:

TB11-7-13

TB11-7-14

Work Order ID 71909

Wednesday, July 13, 2011 12:32:47 PM



Page 2

Item ID: D4406-041
Revision ID: PRELIM
Item Name: Fwd Wearplate Assembly

Accept



Setup Start



Stop



Start Date: 7/13/2011 Start Qty: 1.00
Required Date: 7/15/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspect to pay



QC

Memo

0.00 Day only

Quality Control

130

0.00



Small Fab

Memo

0.00 SB 11/07/18

Small Fab

Form as per dwg D4406

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

trial fit before welding B 11.07.18
~~11.18.07~~

Work Order ID 71909

Wednesday, July 13, 2011 12:32:47 PM



Page 3

Item ID: D4406-041
Revision ID: PRELIM
Item Name: Fwd Wearplate Assembly

Accept



Setup Start



Stop



Start Date: 7/13/2011 Start Qty: 1.00
Required Date: 7/15/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

0.00



Large Fab

Memo

0.00

weld wearplate as per dwg D4406

m118196
m117659

① EL/R 11-07-28

160

0.00



QC

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

11.07.28 ①

170

0.00



Small Fab

Memo

0.00

Apply coating as per dwg D4406

M118000

11/08/11

Work Order ID 71909

Wednesday, July 13, 2011 12:32:47 PM



Item ID: D4406-041
Revision ID: PRELIM
Item Name: Fwd Wearplate Assembly

Accept



Setup Start



Stop



Start Date: 7/13/2011 Start Qty: 1.00
Required Date: 7/15/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00 - inspector to pay



QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11/08/29

RELEASED 11/08/29

AUTH

DATE

11/08/29

Picklist Print

Wednesday, July 13, 2011 12:32:45 PM

Page 1

Work Order ID: 71909

Parent Item: D4406-041

Parent Item Name: Fwd Wearplate Assembly





Start Date: 7/13/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 11.06.06 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4407-1 		Manufactured	No			150	Each	0.0000	1	1			
Bar M304S18GA 		Purchased	No			100	sf	245.6550	3.7	3.894737			
304/316 .050 Sheet													

71911X1



Q 117-28



B11-7-13

Location

Loc Qty

Loc Code

MAT020

85.655

113062

13.655

116135

3

116979

69

MAT021

160

118217

160

118217

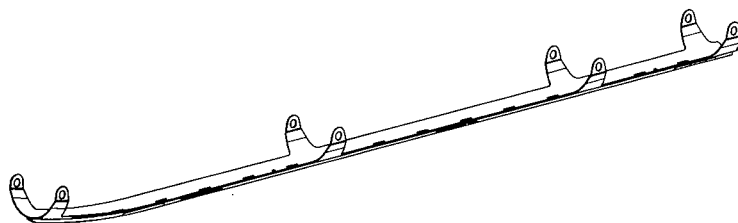
DART AEROSPACE LTD		Work Order: 71909
Description: FWD WEAR PLATE ASSEMBLY		Part Number: D4406-041
Inspection Dwg: D4406-1 Rev: PM4		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

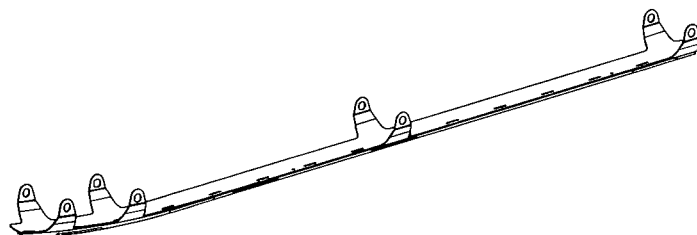
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.561	$\pm .010$.567	✓		VIBO2	
.30	$\pm .030$.300	✗		V	
.13	$\pm .030$.127	✓		V	
.88	$\pm .030$.88	✓		V	
7.77	$\pm .030$	7.762	✓		V	
7.167	$\pm .010$	7.168	✓		V	
Ø .188	$+ .005 - .001$.193	✓		V	
2.43	$\pm .030$	2.446	✓		V	
7.203	$\pm .010$	7.205	✓		V	
7.80	$\pm .030$	7.798	✓		V	
3.63	$\pm .030$	3.626	✓		V	
7.06	$\pm .030$	7.064	✓		V	
4.10	$\pm .030$	4.101	✓		V	
36.08	$\pm .030$	36.00	✓		T B01	
66.06	$\pm .030$	66.06	✓		T	
37.308	$\pm .010$	37.308			T	
63.73	$\pm .030$	63.73			T	
1.77	$\pm .030$	1.77	✓		V	
.050	$\pm .010$.049	✓		V	
12.745	$\pm .010$	12.745	✓		T	

Measured by: IB	Audited by: S	Prototype Approval:
Date: 11-7-13	Date: 11/7/13	Date:
Rev A	Date	Change
		New Issue
Revised by	Approved	
KJ/JLM		



D4406-041 FWD WEARPLATE ASSY



D4406-043 AFT WEARPLATE ASSY

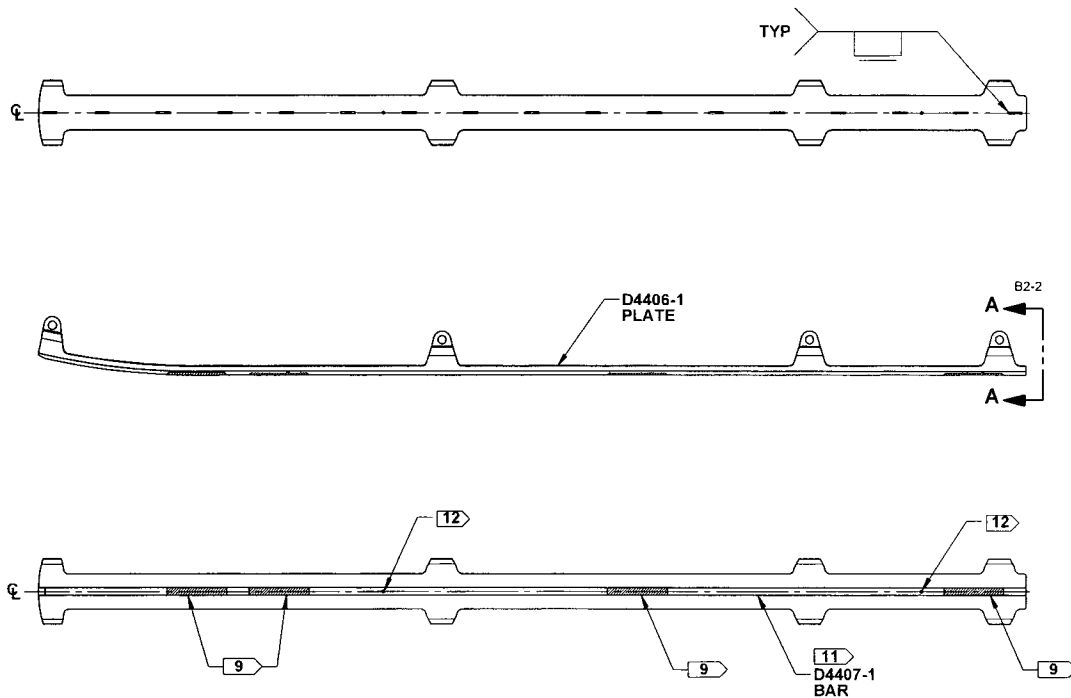
*ulb
71909*

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	1		D4407-1	BAR
6		1	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2 & 3)

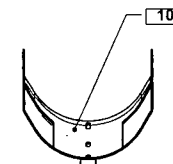
PRELIMINARY ISSUE

11.07.13

PA4	7.77 WAS 7.97 & 7.167 WAS 7.372 (ZN B8-4); 47.883 WAS 47.695 & 53.973 WAS 54.160 (ZN C4-5)	RF	11.07.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4406	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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D4406-041 FWD WEARPLATE ASSY



SECTION A-A
SCALE 2X

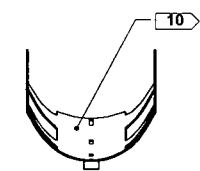
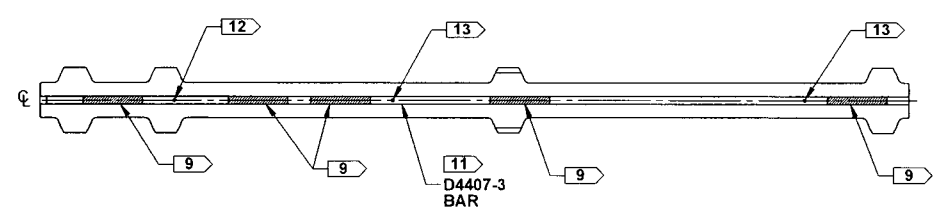
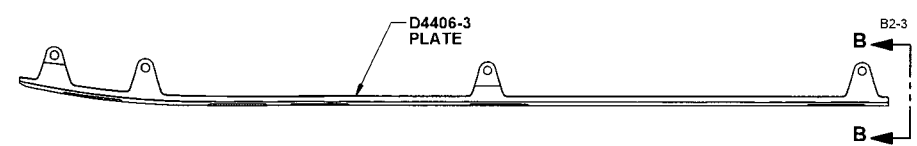
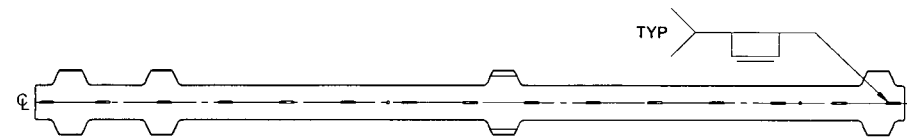
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044.6.1
- 7) WEIGHT: 5.12 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON ALL 3 SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-1 TO D4407-1

PRELIMINARY ISSUE

11.07.13

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D4406-043 AFT WEARPLATE ASSY

C3-3 **SECTION B-B**
SCALE 2X

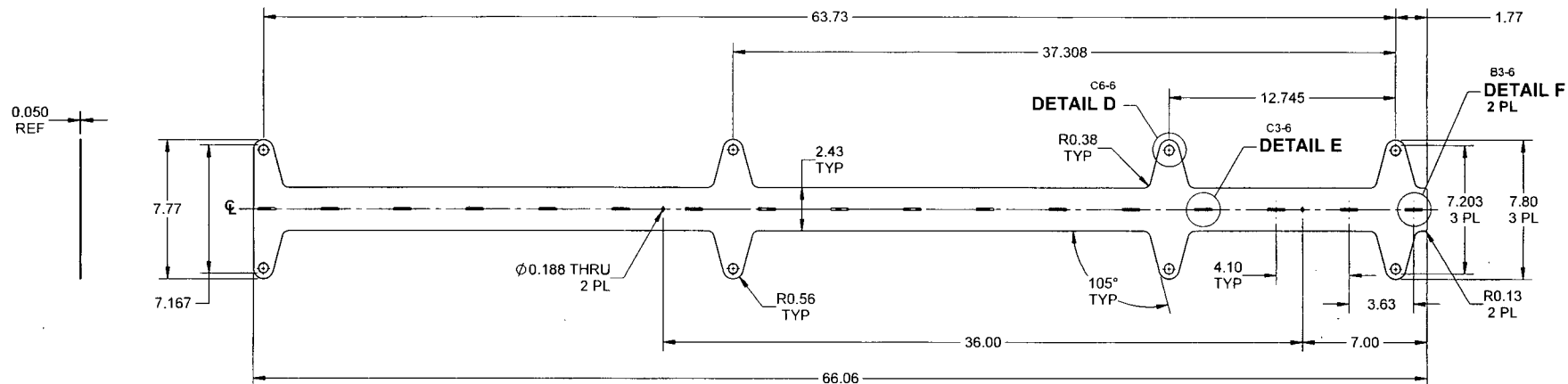
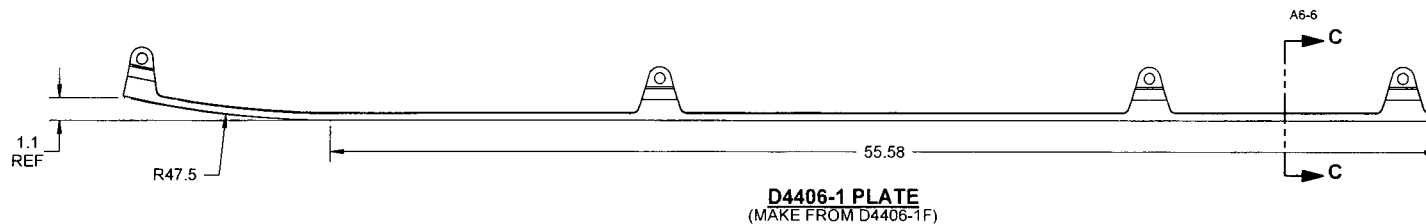
PRELIMINARY ISSUE

11.07.13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.57 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON ALL 3 SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-3 TO D4407-3

DESIGN	RF	DART AEROSPACE LTD	
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MFG. APPR.		D4406	SHEET 3 OF 6
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D4406-1F FLAT PATTERN

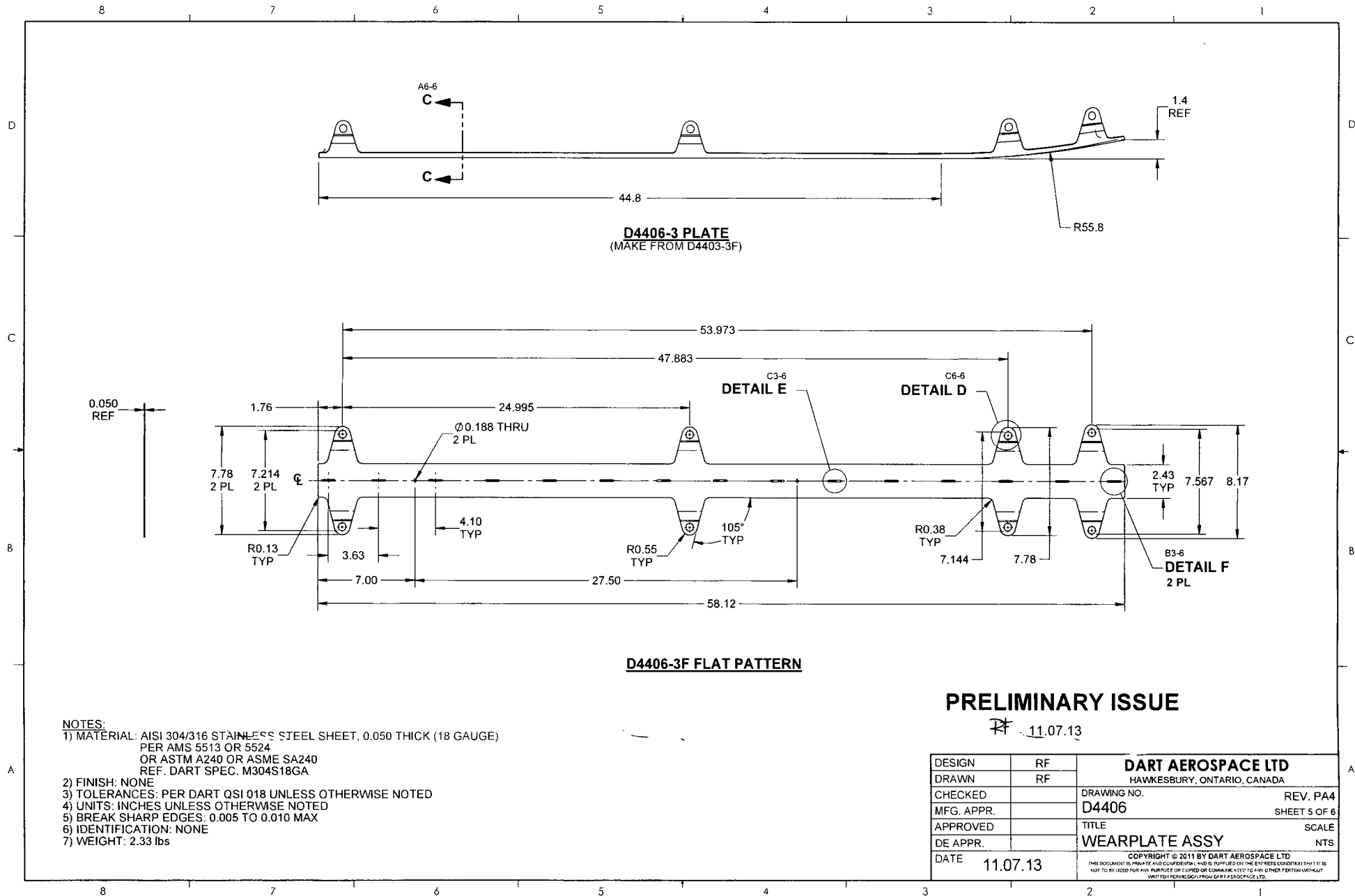
PRELIMINARY ISSUE

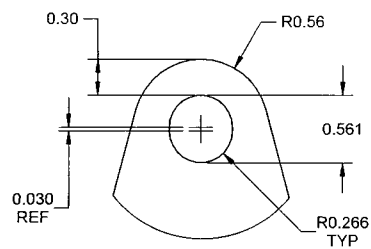
11.07.13

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

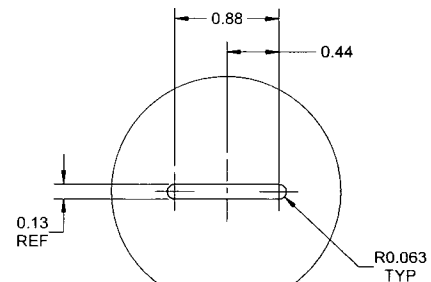
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4406	SHEET 4 OF 6
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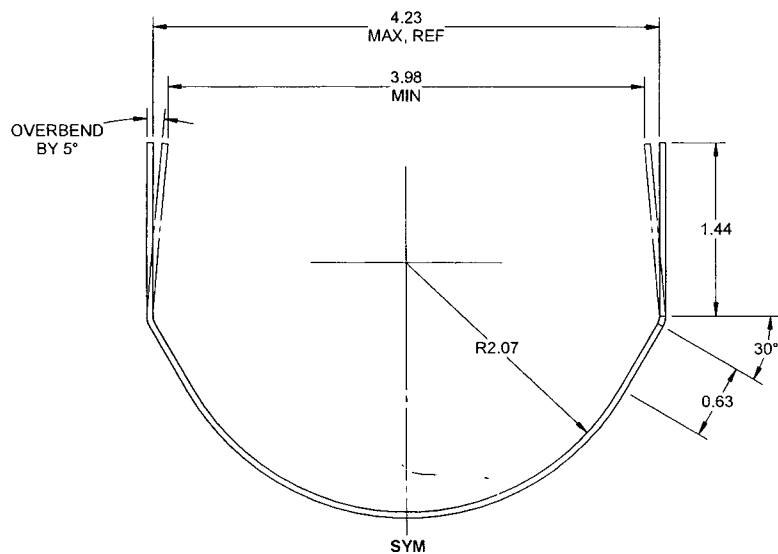
DETAIL D
SLOT DETAIL TYP
SCALE 6X

C3-4
C4-5



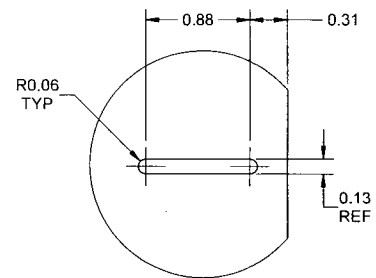
DETAIL E
SLOT DETAIL TYP
SCALE 6X

C2-4
C4-5



DETAIL C
DETAIL TYP
SCALE 6X

D2-4
D6-5



DETAIL F
SLOT DETAIL TYP
SCALE 6X

C1-4
B1-5

PRELIMINARY ISSUE

11.07.13

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4406	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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Linda Lacelle

From: Roberto Fuentes <rfuentes@dartaero.com>
Sent: July 13, 2011 11:45 AM
To: Linda Lacelle
Cc: David Shepherd; Eric Downing; Eric Charbonneau; Mike Petsche; Dan Stow
Subject: D4406 wearplate update (205 wearplate)

Hi Linda,

I posted PA4 new update D4406 dwg and dxf. I correct D4406-1F/-3F per Dan instructions. Please proceed making another set of -1F/-3F, and this time all holes are in alignment with D2580-045 (green skidtube) proceed in weld D4407-1/-3 bar, and check again with the skidtube.

Thanks,
Roberto